



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3307-00-03-PO
Job Sheet 177392



Part No: RBE350A93-3307-00-03-PO **Job Qty:** 50 ea

Part Name: Washer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/10/18

Job Tracking No:

Due Date: 6/8/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE350A93-3307-00 Rev. 2A IPP Rev. A 18.05.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs	6/8/18	6/8/18	0.00	0.00	Purchasing		At 1805/29
110	Packaging	50 pcs	6/8/18	6/8/18	0.00	0.00	Packaging2		At 1805/29
120	QC	50 pcs	6/8/18	6/8/18	0.00	0.00	QC6		38
130	Packaging	50 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3		GA 141 18-05-31
140	QC21-FG	50 Ea	6/8/18	6/8/18	0.00	0.00	QC21		21 MAY 31 2018

Part Op 100 - Issue P/O: 039860 MANUFACTURE RBE350A93-3307-00-03 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

10 Mai 2018 x 50 R L

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A93-3307-00-03P	Washer	50 (1 ea)	100-Purchasing	5075451

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE350A93-3307-00-03P	50	0	0

Part Specifications

Specifications could not be found.

Plex 5/10/18 9:22 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S075460



Part: RBE350A93-3307-00-03

Job No: 177392

Serial No/Batch: S075460

Revision: 2A

Inspector:

Date: 05/29/18



Dart Aerospace Ltd.
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Canada

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RBE350A93-3307-00-03
Job Sheet 173860



Part No: RBE350A93-3307-00-03

Job Qty: 8 ea

Part Name: Washer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3307-00 Rev 2A IPP Rev A 18.01.24 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/14/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	6 pcs		4/14/18	0.00	0.24	MORI SL-154		
120	QC	6 pcs		4/14/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs		4/14/18	0.00	0.00	QC8 Machining-4		
150	Outsource	6 pcs		4/14/18	0.00	0.00	Outsource12		
160	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging2		
170	QC	6 pcs		4/14/18	0.00	0.00	QC6		
180	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea		4/14/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB792 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: 150 - Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE

4 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R1.000	M1018R1.000	.2100 ft (.035 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R1.000	0	0	0

M 304 R1.000

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

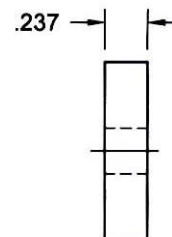
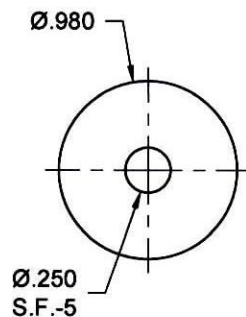
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D WASHER TO P/N -03 & S.F. TO 5. CH'D ALL THREAD TO HEX HEAD CAP SCREW P/N -05 & S.F. TO 3 PER D.W., DELETED -03 WELDMENT.	11/17/09	RJC	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173860

20180501

Handwritten signature



(-03)
WASHER

RED BARN MACHINE	
TITLE TAIL GEARBOX SEAL EXTRACTOR	
DWG NO. RBE350A93-3307-00-03	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9/28/09
SHEET 3 of 4	
DRAWN BY: PERRITT APPROVED: <i>D. Mait</i> HEAT TREAT: BLACK OXIDE FINISH SPEC: USED ON MODEL EUROCDPTER AS350/355	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039860**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039860
PO Date: 5/10/18
Due Date: 6/8/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	C3-4-1P			Load Beam Bushing	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177361											
2	C3-8-2-2P			Solenoid Drilling Jig C3 Hook	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177362											
3	C3-12-2P			Lock Shaft	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177363											
4	C45-3-8BP			Actuator Shaft Bushing Solenoid Side	Firmed	6/8/18	40 pcs	0 pcs	40 pcs	\$0.01/pcs	\$0.40
Line Item Note W/O 177364											
5	C45-3-8AP			Actuator Shaft Bushing	Firmed	6/8/18	40 pcs	0 pcs	40 pcs	\$0.01/pcs	\$0.40
Line Item Note W/O 177367											
6	C45-4-1P			Trunnion Bushing	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177369											
7	C10-23-1P			Keeper Spacer	Firmed	6/8/18	50 pcs	0 pcs	50 pcs	\$0.01/pcs	\$0.50
Line Item Note W/O 177373											
8	RBW6305G01232-3G-5P			Spacer	Firmed	6/8/18	25 Ea	0 Ea	25 Ea	\$0.01/Ea	\$0.25
Line Item Note W/O 177396											

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Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	RBW6305G00232-3G-1P			Base	Firmed	6/8/18	25 Ea	0 Ea	25 Ea	\$0.01/Ea	\$0.25
Line Item Note W/O 177409											
10	RBE350A93-3307-00-03P			Washer	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177392											
11	RBW109-3101-58-1-7P			Handle	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177380											
12	RBW109-3101-58-2-7P			Handle	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177383											
13	RBE350A94-2708-01-01P			Slide	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177384											
14	RBE350A93-3312-03-7P			Washer	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177385											
15	RBE350A93-3312-03-5P			Seat	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177387											
16	RBE350A93-3312-03-3P			Remover / Installer	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177388											
17	RBE350A93-3303-02-5P			Extractor Pin	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177389											
18	RBE350A93-3400-00-1P			Guide	Firmed	6/8/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177390											
19	C2-22P			SWA3 Lifting Bushing	Firmed	6/8/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177393											
20	RBW1205G00231-3G-7P			Washer	Firmed	6/8/18	30 Ea	0 Ea	30 Ea	\$0.01/Ea	\$0.30
Line Item Note W/O 177394											
										Grand Total:	\$8.50
Order Notes											
Procurement Quality Clauses A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM A049 SUPPLIER AWARENESS Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.											

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20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
50	RBE350A93-3307-00-03P	Washer	39860

DAS
38
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in blue ink, appearing to read "Heather Nixon".

Heather Nixon

Vankleek Hill, May 28, 2018